

Date: Tuesday, 3/11/2008 7:57:24 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	END CAP		
Job Number	37743					
Estimate Number	11877					
P.O. Number			Part Number	D2208		
This Issue	3/11/2008	S.O. No.	Drawing Number	D2208 REV C		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type	Drawing Revision	C		
Previous Run	35095		Material			
Written By	<u>JLM</u>		Due Date	3/25/2008	Qty:	20 Um: Each
Checked & Approved By	<u>JLM</u>					
Comment	Est A 01.03.08 New Issue Est B 07.09.11 ech 998 EC verified by: JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S063	6061-T6 .063 Sheet	
		Comment: Qty.: 0.1531 sf(s)/Unit Total : 3.0618 sf(s) 6061-T6 .063 Sheet 5052-H32 or 6061-T6 - .063" Thick Batch <u>105225</u> <u>FB 8-3-18</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2208 Dwg Rev: <u>C</u> <u>FB 8-3-18</u> Prog Rev: <u>C</u>	
		2-Deburr if necessary <u>FB 8-3-18</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <u>FB 8-3-18</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	 <u>5 08/03/18 X20</u>
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	 <u>AS 08/03/18 X20</u>
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>DAT Dual</u>	<u>AS 08/03/18 X20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 122208 PAR #: N/A Fault Category: Pad / FFB' PSS' med & small NCR: Yes No DQA: N Date: 08/08/20
QA: N/C Closed: X Date: 08/03/24

WORK ORDER NON-COMPLIANCE (NCR)

NOTE: Date & initial all entries

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Drawing Name: END CAP

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Part Number: D2208

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D08103/20

Job Completion



= 2008/3/20

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

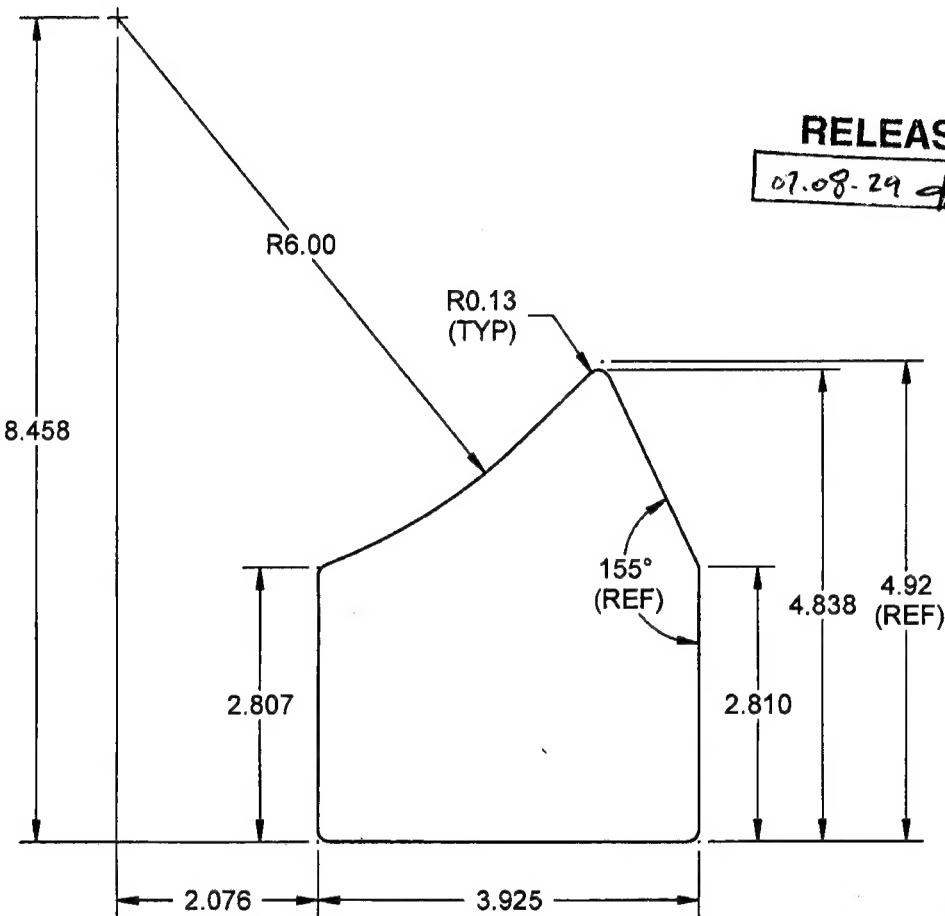
NOTE: Date & initial all entries

DART

DESIGN <i>PF</i>	DRAWN BY <i>BS</i>
CHECKED <i>PH</i>	APPROVED <i>TM</i>
DATE 07.07.05	TITLE END CAP

OSPACE LTD
JRY, ONTARIO, CANADAREV. C
SHEET 1 OF 1SCALE
1:2

REV	DATE	DESCRIPTION
A	94.09.01	NEW ISSUE
B	01.02.22	REDRAWN
C	07.07.05	REDESIGN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37743*

D2208 END CAP

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.063) OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

DART AEROSPACE LTD	Work Order:	37743
Description: END CAP	Part Number:	D2208
Inspection Dwg: D2208 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>AB</u>	Audited by:	<u>J</u>	Prototype Approval:	<u>n/</u>
Date:	<u>8-3-18</u>	Date:	<u>08/03/18</u>	Date:	<u>/</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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